



APPLYING

RELEASE AGENT

ABABOL release products are based on high performance polymers. It brings to the surface of the mould high anti-sticking properties and lubricity. The release agents make a barrier between the mould and the piece, helping the extraction and avoiding sticking.

ABABOL release agents suits all kind of moulds, products and processes. We have a highly qualified technical team which can help you to find the best solution to your specific needs.

ABABOL Products have the technology that allows the mould to release free of solvents in sectors and applications such as: pieces made with polyester gel coat, vinyl ester or epoxy, in pieces are going to be repainted or in pieces with a high probability of self-molding. All that without diminishing the efficiency in demolding, neither generate problems in the production process. For any doubt consult our TDS and MSDS, or visit our website www.ababoldemould.com

We have three ranges of release agents products:

1- High performance polymers emulsions formulated without organic solvents, not detaching either CFC or any other VOC, complying the highest environmental requirements.

·ABABOL G

Especially designed for high abrasion materials or where an extra lubricity and anti-stick in the mould is needed.

Release agent recommended for thermoplastic products such as: polyethylene, phenoplasts, amino plastics... and heat-stables polymers based in polyester, vinyl derivates, epoxies, gel coats, etc.

·ABABOL N

Recommended for the rubber industry and elastomers, in sectors such as tyres, automotive, conveyor belts, hoses, gaskets, rubber, suspensions, rigid wheels...

·ABABOL NRB

Is a high viscosity release agent, recommended for rubber and elastomers, specially tyres, conveyor belts...

·ABABOL GRAF

Is a release agent that compound the emulsion of polymers with graphite which gives high lubricity combined with the demolding process.

IT DOES NOT CONTAIN MICA which makes it optimal in those cases where this material can stain the part in the industrial process such as tire manufacturing.

Recommended for rubber and elastomers, specially tyres, conveyor belts, pipes and nozzle.

ABABOL GM

Is a formulation based of high performances polymers and a mix of mineral laminar loads such as mica, specially selected to improve the lubricity, as well as a high performance in the release process. This release agent is recommended for rubber and elastomers, especially tires, conveyor belts, pipes and hoses...

ABABOL H

Is a release agent recommended for the Polyurethane sector, especially for the demolding of high abrasion materials, or that require extra lubricity and non-stick in the mould.

ABABOL RAFEB

Is a release agent designed for apply directly on EPOXI TOOLING BLOCKS and PU TOOLING BLOKS, of high density or low porosity, allowing the demolding directly over the surface without needing sealers or coating paints.

2- High performances polymers emulsions formulated on a base of different organic solvents, to achieve high penetration into the mould.

ABABOL TOT MC

Is a release agent designed for the polymer matrix composites industry (polyester, vinyl ester, epoxy, polyurethane, rubber and elastomers). It has different versions with less speed evaporation such as **TOT-MCL**.

ABABOL P

Is a high performance release agent, designed for the polymer matrix composites industry (polyester, vinyl ester, epoxy), polyurethane, rubber and elastomers.

3- Waxes/Polyvinyl Alcohol

CERA NW65

Is a manual application SOLID wax specially designed for the mould release polymers products.

POLYVINYL ALCOHOL

Polyvinyl alcohol solution for spray or brush application.

APPLYING INSTRUCTIONS

There are two main ways of applying release agents: manually or with a spray gun, both for solvent-free products as well as the organic solvents. NB: In the case of waxes follow the technical forms.

For the right manual application, it's important to take some precautions:

Don't use cotton towels, sponges, or any other absorb important material, because they will absorb too much product.

Each piece of paper or towel you have used to apply the release agent must be discarded and you must avoid mixing release agent polymerized with new ones.

Adding more quantity of release agent other than recommended does not improve the release capacity.



APPLYING RELEASE AGENT

Never use materials with pigments or other soluble materials on water because this can have an influence in the polymerization of materials. We recommended a piece of cellulose paper.

Check TDS to see how temperature affects the curing of each product type, number of layers recommended and additional information.

At www.ababoldemould.com, there are videos where you can see the manual application of each Ababol release agents in different surfaces.

APPLYING MANUALLY

Wet some clean paper with the release agent and apply uniformly on the surface of the mould. We can use also manual spray systems to apply the material.

Wipe of the surface after applying. The wipe off process helps a uniform distribution of the material. For solvent free products wipe off process must not be done immediately, except when the surface is hot.

Standard cure time of release agents it is around 15 minutes at 20-25°C. After that time mould is ready for a new coat or to start production.

Consult our TDS and MSDS of each product to know how affect the temperature to the curated process, number of recommended layers and other important information.

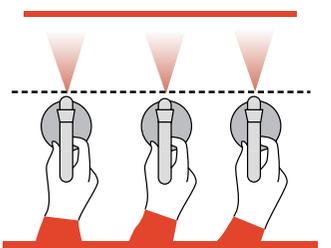
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APPLYING WITH A SPRAY GUN

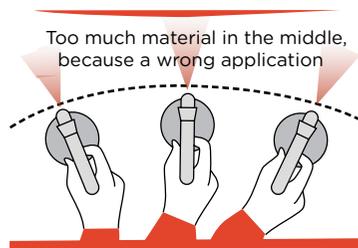
As in the manual application, the applying with a spray gun also needs some advices.

The nozzle recommended must be similar or lower than 0,5mm with air assistance. The volume of material must be controlled.

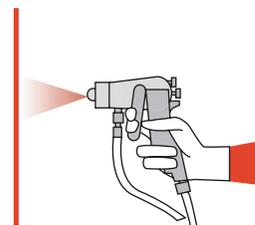
The movement of the gun must be uniform to guarantee a correct proportion of release agent.



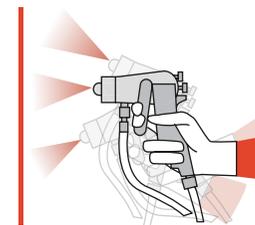
Correct movement procedure. Arm move.



Too much material in the middle, because a wrong application. The arm movement must to follow the mould surface, it is not correct to move just your wrist.

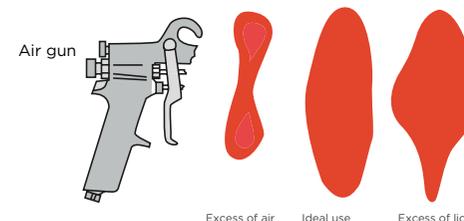


Correct position.



Wrong position, with movements. The spray gun must be right to left not up to down.

Hand speed must be adjusted with the volume of release agent applied.



In this picture you can see the kind of mark must to make the product, by leaving the spray gun fixed on a point on a horizontal surface.

As guidance data at room temperature of 20-25°C.

| PRODUCT TYPE | DISTANCE TO THE MOULD SURFACE | APPLYING WIDTH |
|----------------------|-------------------------------|----------------|
| SOLVENT FREE (G,N,H) | 20-30 cm | 30-40 cm |
| ABABOL P, TOT MC | 25-35 cm | 30-40 cm |

In solvent-free products, the spray gun application is more difficult, because we must to be sure a perfect atomization to avoid excess of release agent. For this you should spray with an air/material ratio of approximately 6:1 and with a very low product pitch. The purpose is to make multiple passes on the surface, with very little amount of material in each of them. Then the evaporation will be almost immediate.

As we show in the application videos, you need to spend several seconds without moving the gun to see how the material accumulates. The mould temperature is another factor to consider when applying spray. The hotter the mould is, the faster the polymerization on it will be, so we can decrease the number of sprays and increase the material passing to the spray gun.

If you need more information about our Ababol products, you can visit our web www.ababoldemould.com or contact us sending an email to the next address: contacto@cladescomposites.com

